: BAFFLE ASSEMBLY

Tuesday, 16/12/2008 2:13:17 PM Julie Dawson

Process Sheet

Drawing Name

User: Customer Job Number **Estimate Number** P.O. Number Prsht Rev. First Issue Comment

: CU-DAR001 Dart Helicopters Services : 44125 - 2

: 11265

This Issue : 16/12/2008 S.O. No. :

: NC

: 36597 Previous Run

Written By

Checked & Approved By

: Est Rev:A

Type

New Issue Est Rev:B Now on Waterjet 06-09-06 JLM

05-12-06 JLM

: SMALL /MED FAB

Part Number : D3276042 **Drawing Number** : D3276 REV B

Project Number : N/A **Drawing Revision** Material

Due Date : 30/12/2008 Qty:

10 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: 1.0

M6061T6S040

Description:

6061-T6 .040 Sheet

Comment: Qty.: 1.0715 sf(s)/Unit Total: 10.7153 sf(s)

Material: 6061-T6 (QQ-A-250/11) 0.040" thick

(M6061T6S.040)

Batch: 109396

2.0 WATER JET

FLOW WATER JET



Comment: FLOW WATER JET 1-Cut as per Dwg D3276

> Dwg Rev: Prog Rev:

1B 8-12-17

2-Deburr if necessary

QC2

1B8-177

INSPECT PARTS AS THEY COME OFF MACHINE



HB8-12-17

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

3.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

Dart	Aerospace	l td
Dail	ACIUSPACE	Lu

W/O:	n't		WORK O	RDER CHANG	ES					
DATE	STEP	PR		THE STATE OF	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector	
						193				a de la composición dela composición de la composición de la composición de la composición dela composición de la composición dela composición dela composición de la composición de la composición dela composición de la composición dela c
Andrew Andrew										33.6
	au fire y	**		(1) · · · · · · · · · · · · · · · · · · ·	9					1
						1			- 4	
Part No:		PAR #:	Fault Category:		NC	R: Yes	No DQ	A:	Date: _	
	Re	solution:	Disposition:		QA	: N/C C	losed:		Date: _	
NCR:		Ţ	WORK ORDER NO	N-CONFORMA	NCE	(NC	R)			124.1
	-	Description of NO	Correcti	ve Action Section	on B					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
Transport		Description of NC Corrective Action Section B				Verification	Ammunust	A		
DATE	STEP	Section A	Initial Action Description Sign Chief Eng Chief Eng Date			Section C	Approval Chief Eng	Approval QC Inspector		
	£									
								1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1		
				THE ATTEMPT OF THE STATE OF						
			=							
								are est		
			į.							
				はする大島である 1 mm	4.74					
	1 0 T 0			7, 7, 1,52			16-51			
	1.00				- Ben			XX.		
				1.0						

NOTE: Date & initial all entries

Date: Tuesday, 16/12/2008 2:13:17 PM User: Julie Dawson **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: BAFFLE ASSEMBLY Job Number: 44125 Part Number: D3276042 Job Number: Seq. #: Machine Or Operation: Description: 2-Roll as per Dwg D3276 6.0 BRAKE NC NC BRAKE Comment: NC BRAKE Form as per Dwg D3276 7.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP 8.0 HAND FINISHING HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 9.0 POWDER COATING 09996 Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 START TIME: OVEN TEMPERATURE: FINISH TIME: 10.0 QC3 Comment: INSPEC OWDER COAT/CHEMICAL CONVERSION D2464 11.0 3/4 Seal Comment: Qty.: 2.2500 f(s)/Unit Total: 22.5000 f(s) Pick: Description Batch ~ **Qty Part Number** 08/13/2019 27.0" Neoprene Seal D32763 12.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s) Pick: Qty Part Number Description B36633 1 D3276-3 Decal

Form: rprocess

Page 2

Dart Aeros	pace I	Ltd
------------	--------	-----

	oopaoo									
W/O:			WO	RK ORDER CHANG	ES			The same		
DATE	STEP	- PRO	OCEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								196		
					u.					
Part No: PAR #:			Fault Categ	ory:	NC	R: Yes N	lo DQ	A:	_ Date: _	
			Disposition	Disposition: QA: N/C				Closed: Date:		
NCR:			WORK ORDE	R NON-CONFORMA	ANCE	(NCR)	W			
DATE	STEP	Description of NC Corrective Action			Section B			cation	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Sect	on C	Chief Eng	QC Inspector
				3				3		

NOTE: Date & initial all entries

Tuesday, 16/12/2008 2:13:17 PM Date: User: Julie Dawson **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: BAFFLE ASSEMBLY Job Number: 44125 Part Number: D3276042 Job Number: Seq. #: Machine Or Operation: Description: 13.0 SMALL FAR 1 SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D3276 14.0 INSPECT WORK TO CURRENT Comment: INSPECT WORK TO CURRENT STEP 15.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 16.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No: PAR #:		PAR #:	Fault Categ	gory:	NCR: Yes No DQA: _				Date:		
		esolution:	ution: Disposition:					QA: N/C Closed: Date:			
NCR:			WORK ORDE	R NON-CONFORMA	NCE	(NCR)			Lia-	
		Description of NC	Corrective Action Se		on B		Verification		Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date		Section C	Chief Eng	QC Inspector	
	- [-44]										

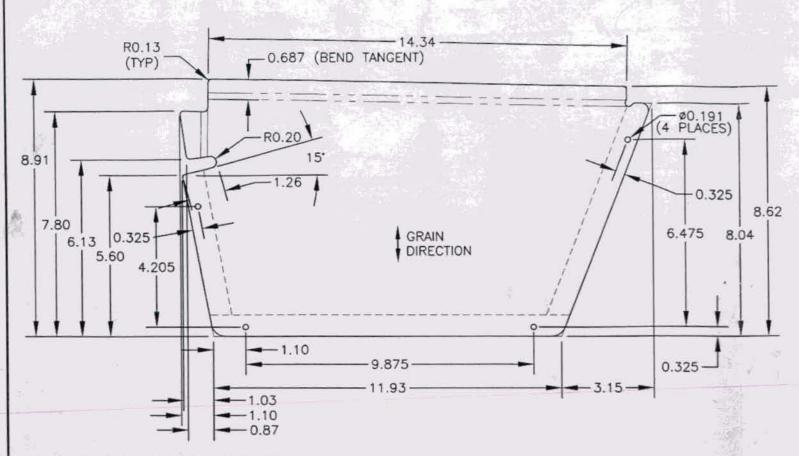
NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 4412	5
Description: Baffle	Part Number: D32	76-1
Inspection Dwg: D3276 Rev: B	Page	1 of 1

	_x	First Arti	cie	Prote	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comm	nents
14.34	+/-0.030	14.34	×				
8.62	+/-0.030	8,627	*	-		7	
8.04	+/-0.030	8,057	×	21		755	<u>, =</u>
Ø0.191	+0.005/-0.000	.194	*			La A	No.
0.325	+/-0.005	(322	>4		Take 1	1.12	
11.93	+/-0.030	11.931	×				C.
9.875	+/-0.005	9.878	*		100		The .
5.60	+/-0.030	5.62	X			30	10, 1X
7.80	+/-0.030	7.815	¥				
8.91	+/-0.030	8,904	y		- 44.0	7.77	
1.26	+/-0.030	1.267	4	-		1/3	a 100 1845
Grain Direction	N/A		*	1.		T.V	- Ly
1 1000	12 7					Y.	5. 50
47.5	-		160				
	Si il		120			- 1	
1 pg 1 m	F		100		£ -0	100	
14 16 17		TATES	10 -				The state of
1 44	J. Committee	7-7-1780					13.47
The state of the s		10 4	- 7				AL PROPERTY.
THE SAME	China and	- Contraction of the contraction					
4.50							100
9 7							
			-				
Measured by:	B	Audited by:		·	Prototype A	nnroval	N/A
Date:	8-12-17	Date:	0	1/7	r tototype A	Date:	N/A

Rev	100,000,000	Change		Revised by	Approved
Α	05.04.26	New Issue	P/O D044-717-011	Revised by KJ/JLM	SAII
				()	100/





D3276-1 BAFFLE (FLAT PATTERN)

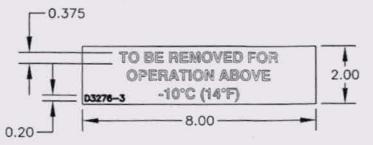
1) MACHINE PER DWG FILE "D3276-A.DWG"

2) MATERIAL: 6061-T6 ALUMINUM 0.040 THICK (QQ-A-250/11) (REF DART SPEC. M6061T6S.040)

3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3

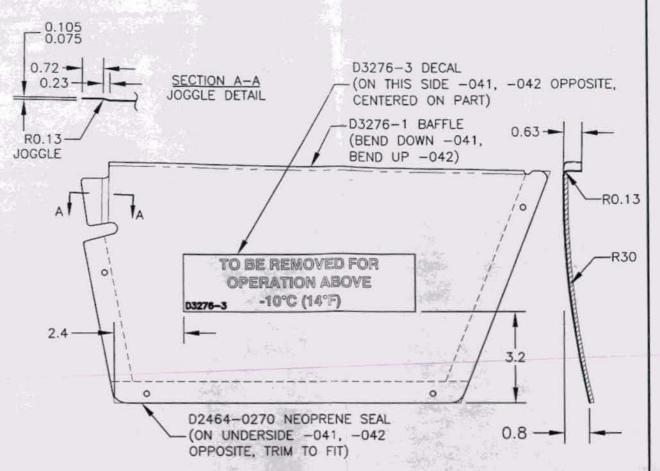
4) ALL DIMENSIONS ARE IN INCHES

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3276-3 DECAL

- 1) RED LETTERING ON WHITE ADHESIVE BACK
- 2) MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3276-041 BAFFLE ASSEMBLY, LH (SHOWN)
D3276-042 BAFFLE ASSEMBLY, RH (BEND/JOGGLE OPPOSITE)



SHOP COPY
RETURN TO
ENGINEERING
UNCONT ROLLED COP
SUBJECT TO AMENDMEN
WITHOUT NOTICE
WORK OR SER

	В	05.01.25	NEW ISSUE				
	A	05.01.07					
, N ISE	DESIGN CF	DRAWN BY	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA			
	CHECKED	APPROVED	DRAWING NO. D3276	REV. B SHEET 1 OF 1			
	DATE	17	TITLE	SCALE			
	05.01.25	A be	BAFFLE ASSEME	BLY 1:3			

COPYRIGHT © 2004 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

